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1270 Aberdeen St
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D350-591-311
Job Sheet 192418

DAS
21
9-89

DAS
24
9-89



Part No: D350-591-311

Job Qty: 4 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/25/19

Job Tracking No:

Due Date: 4/24/19

Created By: Marie Lajeunesse

Type: Stock

Description: CHG 001

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Large Fab - Steps - 1	4 pcs	4/24/19	4/24/19	0.00	3.97	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2	DAS 24 9-89	
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	QC 9	4 pcs	4/24/19	4/24/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS 43 9-89	
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	4 pcs	4/24/19	4/24/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS 43 9-89	
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



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Container No: S180862



Part: D350-591-311

Job No: 192418

Serial No/Batch: S180862

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967NE 04/12/21, BRAZIL 1

140 Handfinish - 1-1 Chemical-B4B	4 pcs	4/24/19	0.00 0.73	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	19-05-15
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	4 pcs	4/24/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	24 DAS
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
180	Large Fab - Steps - 2 - B4B	4 pcs	4/24/19	0.00 3.97	Large Fab - 1 - B4B
					Large Fab - 10 - B4B
					Large Fab - 2 - B4B
					Large Fab - 3 - B4B
					Large Fab - 4 - B4B
					Large Fab - 5 - B4B
					Large Fab - 6 - B4B
					Large Fab - 7 - B4B
					Large Fab - 8 - B4B
					Large Fab - 9 - B4B
190	QC 10	4 pcs	4/24/19	0.00 0.00	QC 10 - 10
					QC 10 - 18
					QC 10 - 24
					QC 10 - 43
					QC 10 - 50
					QC 10 - 58
					QC 10 - 9
200	QC 5	4 pcs	4/24/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
210	Handfinish - 1-2- Chemical-B4B	4 pcs	4/24/19	0.00 0.73	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B

				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
220	Powdercoat - 1 White Gl(A)- B4B	4 pcs	4/24/19	0.00 1.16	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
230	Handfinish - 3-1- WingWalk- B4B	4 pcs	4/24/19	0.00 0.73	Handfinish - 3 - 1 - B4B
					Handfinish - 3 - 2 - B4B
					Handfinish - 3 - 3 - B4B
					Handfinish - 3 - 4 - B4B
					Handfinish - 3 - 5 - B4B
240	QC 3	4 pcs	4/24/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
250	Packaging 1-1 - Pick Kit - B4B	4 pcs	4/24/19	0.00 0.00	Packaging 1 - 1 - B4B
					Packaging 1 - 2 - B4B
					Packaging 1 - 3 - B4B
					Packaging 1 - 4 - B4B
					Packaging 1 - 5 - B4B
					Packaging 1 - 6 - B4B
					Packaging 1 - 7 - B4B
					Packaging 1 - 8 - B4B
					Packaging 1 - 9 - B4B
					Packaging 1 - 10 - B4B
					Packaging 1 - 11 - B4B
					Packaging 1 - 12 - B4B
					Packaging 1 - 13 - B4B
					Packaging 1 - 14 - B4B
					Packaging 1 - 15 - B4B
					Packaging 1 - 16 - B4B
					Packaging 1 - 17 - B4B
					Packaging 1 - 18 - B4B
					Packaging 1 - 19 - B4B
					Packaging 1 - 20 - B4B

				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260	QC 4	4 pcs	4/24/19	0.00 0.00	QC 4 - 28
					QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
270	Packaging 3-1 - Stock - B4B	4 pcs	4/24/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
275	DC - 1 - B4B	4 pcs	4/24/19	0.00 0.00	DC - 1 - B4B
					DC - 2 - B4B

JRB

JRB

Fg108

DAS JUN 06 2019
21
3-55

280 QC 21 - FG

4
pcs

4/24/19

0.00 0.00

QC 21 - FG - 21

DAG JUN 06 2019

QC 21 - FG - 70

21

QC 21 - FG - 53

9-89

Part Op 110 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig
 Descriptions: DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 138840 3-Grind End Plate flush
 120 - (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Weld per dwg A/R Aluminum rod Batch: 138840) 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet
 out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate
 as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.
 190 - (QC10- Inspect visual per QSI004- ground welds)
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (Chemical Conversion Coat per QSI005 4.1)
 220 - (White Gloss (Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 3:40 OVEN TEMPERATURE: 330
 FINISH TIME: 4:10 M151749
 230 - (Wing Walk as per dwg QSI005 4.4 Batch 5163430)
 240 - (QC3- Inspect Part Finish)
 250 - (Pick Kit)
 260 - (QC4- 100% Inspect kits for completeness)
 270 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-591-311 Location :
 FG109
 275 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-311 CHG001
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	8 pcs (2 ea)	110-Large Fab - Steps - 1	<u>5125543</u>
D3219-1	Plate	8 pcs (2 ea)	110-Large Fab - Steps - 1	<u>5125734</u>
D3272-1	Step	4 pcs (1 ea)	110-Large Fab - Steps - 1	<u>5180251</u>
D3065-041	Step Leg Assembly	<u>34</u> pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	<u>5102779</u>
D3066-1	Spacer	<u>68</u> pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	<u>5128757</u>
MS20600-AD4W4	Rivet	<u>48</u> Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	<u>5191237</u>
AN3-35A	Bolt	<u>4</u> 8 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5158557</u>
AN4-13A	Bolt	<u>16</u> 32 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5149282</u>
AN5-36A	Bolt	<u>4</u> 8 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5162648</u>
D2230-3	Mounting Lug	<u>8</u> 16 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5126022</u>
D2618	Bushing	<u>4</u> 8 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5146466</u>
D2856-400-720	Abrasion Strip 4" X 7.20"	<u>4</u> 8 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5186499</u>
D3235-1	Mounting Lug	<u>4</u> 8 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5150055</u>
D3278-041	Support Assembly	<u>2</u> 4 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5109492</u>
MS21042L3	Nut	<u>4</u> 8 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5166712</u>
MS21042L4	Nut	<u>16</u> 32 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5158232</u>
MS21042L5	Nut	<u>4</u> 8 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5167653</u>
NAS1149D0363J	Washer	<u>8</u> 16 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5162884</u>
NAS1149D0463J	Washer	<u>32</u> 64 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5158585</u>
NAS1149D0563J	Washer	<u>8</u> 16 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5174288</u>
DSI 9410-011	Amends Installation Of D350-591-311/312 Steps	4 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5156419</u> <u>5167775</u> <u>X1</u>

009773

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	8	177	0
	D3219-1	8	163	0
	D3272-1	4	10	0
180-Large Fab - Steps - 2 - B4B	D3065-041	4	3	0
	D3066-1	8	151	0
	MS20600-AD4W4	64	3,409	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	8	580	0
	AN4-13A	32	1,745	0
	AN5-36A	8	177	0
	D2230-3	16	127	0
	D2618	8	196	0
	D2856-400-720	8	146	0
	D3235-1	8	240	0
	D3278-041	4	3	0
	DSI 9410-011	4	1	0
	MS21042L3	8	3,110	0
	MS21042L4	32	3,993	0
	MS21042L5	8	697	0
	NAS1149D0363J	16	1,791	0
	NAS1149D0463J	64	6,355	0
	NAS1149D0563J	16	1,473	0
Part Specifications				
Specifications could not be found.				

Plex 3/25/19 8:17 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								